

Date: Tuesday, 27/01/2009 10:57:42 AM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b>	: CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b>	: 350 SKIDTUBE ASSEMBLY RH
<b>Job Number</b>	: 45292		
<b>Estimate Number</b>	: 10268		
<b>P.O. Number</b>	:	<b>Part Number</b>	: D350636014UP
<b>This Issue</b>	: 27/01/2009 <b>S.O. No.</b> :	<b>Drawing Number</b>	: D2750 REV F
<b>Prsht Rev.</b>	: NC	<b>Project Number</b>	: N/A
<b>First Issue</b>	: 27/01/2009 <b>Type</b> : SKIDTUBES	<b>Drawing Revision</b>	: F
<b>Previous Run</b>	: 44103	<b>Material</b>	:
<b>Written By</b>	:	<b>Due Date</b>	: 03/03/2009 <b>Qty:</b> 1 <b>Um:</b> Each
<b>Checked &amp; Approved By</b>	: <u>JUD 09.01.27</u>		
<b>Comment</b>	: Est Rev:H 02.09.25 Rearranged procedure steps KJ Est Rev:I 05.12.08 Rearranged procedure steps EC Est Rev:J 06.03.30 Per rev. D EC Est Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By:EC Est Rev:M 08-09-23 revF as per dwg DD verified by:ec		

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	DC	DOCUMENT CONTROL
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**Comment:** DOCUMENT CONTROL

Photocopy blue file and type labels per PPP D350-636-014 CHG 004

2.0	D26003BENT	Extrusion Bent
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2600-3-Bent Extrusion (Bent)

B-45063

ALW 9-1-29 (1)

3.0	D2744	Cap
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Cap

Batch

B-42713

BE 9-1-30

4.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1
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**Comment:** LANDING GEAR RESOURCE 1

① 1- Mark cut line on aft end of D2600-3-Bent using Jig DT 8150. Cut to length as per Dwg D2750. Deburr end

② 2-Drill pilot holes as per Dwg D2750 sheet 7 (D2750-4 details). Drill using drill Jig DT8150 &amp; DT8864.

ALW 9-1-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 45292

Part Number: D350636014UP

Job Number:



Seq. #:	Machine Or Operation:	Description :
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- |     |   |  |
|-----|---|--|
| 3-  | Mark fwd end for cutting using Drill Jig DT 8150 & DT8864 and cut as per dwg D2750.   |  |
| 4-  | Drill pilot holes for blade fitting bolt using DT8983. Open to 0.500".  |  |
| 5-  | locate DT8929 off of blade fitting holes and drill pilot holes for blade fitting.   |  |
| 6-  | Open up holes for section BE-BE to 0.375 (2 holes per side) and blade fitting location holes to 0.500" (total of 4 holes per side) as per dwg D2750. Open holes for ground handling and detail A-B to 0.500" (8 holes per side) |  |
| 7-  | Drill pilot holes for wearplates as per Dwg D2750 using DT8108 and open to 0.297"   |  |
| 8-  | Open up holes of Detail A-A to 0.297" (total of 2 holes per side)   |  |
| 9-  | Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left from bending as per QSI 004<br>A/R Aluminum Rod <i>M10295 BE 09-1-30</i>   |  |
| 10- | Grind welds flush as per Dwg D2750 <i>SL 9-1-31</i>   |  |
| 11- | scribe batch #. <i>- ANM 9-1-29</i>   |  |

*-ANM  
9-1-29*

5.0 QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

*S 09/02/02 (H)*

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*S 09/02/02 (H)*

7.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

*ANM 09-02-02*

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*DP 9-2-2*

W/O:		WORK ORDER CHANGES					
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Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 45292

Part Number: D350636014UP

Job Number:



Seq. #:

Machine Or Operation:

Description :

9.0

D2739

350 I Beam



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Web

Batch: B45373

DP 9-2-2

10.0

D34901

Cross Bolt Spacer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Crossbolt spacer

Batch: B44796

(4)

N 9-2-2

11.0

D34905

Cross Bolt Spacer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Crossbolt spacer

Batch: B41325

(4)

N 9-2-2

12.0

D2743

Crossbolt Spacer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Crossbolt Spacer

Batch: B473110

(8)

N 9-2-2

13.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open up holes section BE-BE 0.500" (4 per side) as per dwg D2750

2-Open holes section BC-BC 0.3125" (4 per side)

3-Open up holes of Detail AB and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750.

4-Chamfer holes of section BE-BE, BC-BC, AB and ground handling (welding instructions on sheet 11)

5-Deburr and blow out all chips from inside of tube. Prepare tube for welding, remove alodine as required.

6-Bond web D2739 in place as per QSI 015

A/R Sikaflex-291

batch: 109883

exp. date: 9-7-11

N 9-2-2

7- Weld spacers D3490-1, D3490-5 and D2743 as per dwg D2750 & QSI004

DP 9-2-2

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 45292

Part Number: D350636014UP

Job Number:



Seq. #:

Machine Or Operation:

Description :

(welding instructions on sheet 11)

A/R Aluminum Rod batch: M110295 BE 09/02/03

8-Grind welds flush as per Dwg D2750

9-Spot face ground handling holes (total of 4 places per side) as per dwg D2750

10-Debur holes + Bull tube

pm 09-02-03

14.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

09/02/04 (40)

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09/02/04 (40)

16.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Pressure wash as per QSI 005

FL 09/02/06 (P)

17.0

POWDER COATING

POWDER COATING



Comment:

DO NOT PAINT !!!!!!!

ASSEMBLE ALODINED ONLY

Alodine FL 09/02/06

18.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Inspect for foreign object per QSI 024

09-02-09 (XU)

19.0

ALS41032225

Insert



Comment: Qty.: 38.0000 Each(s)/Unit Total: 38.0000 Each(s)

Insert

Batch: M1109817

09-02-09 (XU)

W/O:		WORK ORDER CHANGES					
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Job Number: 45292

Part Number: D350636014UP

Job Number:



Seq. #:	Machine Or Operation:	Description :
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20.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1  
1-Install inserts as per dwg D2750

2-assemble o'ring as per dwg D3492 and apply o'ring lube  
A/R 55-o'ring lube batch: 11161223

Handwritten: 09-02-09

21.0	D2745	Bushing
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Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)  
Bushing  
Batch: 1344893

22.0	D37911	Wearplate
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Wearplate  
Batch: 1344912

23.0	D37931	Wearshoe
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Wearshoe  
Batch: 1344062

24.0	D37933	Wearshoe
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Wearshoe  
Batch: 1344913

25.0	D37941	Gasket
------	--------	--------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Gasket  
Batch: 13421914

Handwritten: 09-02-09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 45292

Part Number: D350636014UP

Job Number:



Seq. #:	Machine Or Operation:	Description :
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26.0

D37943

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Gasket

Batch: 13 45356

94

27.0

D353525

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch: 13 44905

94

28.0

D353625

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: 13 44647

94

29.0

D35371

Wearpad



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

WEARPAD

Batch: 13 44649

94

30.0

D36311

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

WASHER

Batch: 13 44670

94

31.0

D3488042

Blade Fitting Assembly, RH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Blade Fitting, RH

Batch: 13 43122

94

32.0

NAS1611010

O-RING



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

O-RING

NAS1611-010 batch: M 110715

(or MS28775-010) batch: \_\_\_\_\_

94

09-02-09

(94)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 45292

Part Number: D350636014UP

Job Number:



Seq. #:	Machine Or Operation:	Description :
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33.0	NAS1611005	O-RING
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

O-RING

batch: M 105888

JD

34.0	D3492041	Plug Assembly
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Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

PLUG ASSEMBLY

Batch: 1343816

JD

35.0	D3492045	Plug Assembly
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Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

PLUG ASSEMBLY

Batch: 1343452

JD

36.0	AN3C5A	Bolt
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Comment: Qty.: 34.0000 Each(s)/Unit Total : 34.0000 Each(s)

Bolt

Batch: M 110468

JD

37.0	AN3C6A	BOLT
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: M 108880

JD

38.0	AN6C44A	BOLT
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

BOLT

Batch: M 110155

JD

39.0	AN8C35A	BOLT
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

BOLT

Batch: M 110105

JD

09-02-09

(2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 45292

Part Number: D350636014UP

Job Number:



Seq. #:	Machine Or Operation:	Description :
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40.0	AN960C10L	washer
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Comment: Qty.: 38.0000 Each(s)/Unit Total : 38.0000 Each(s)

washer

Batch: M110584

JH

41.0	AN960C816L	WASHER
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WASHER

Batch: M110139

JH

42.0	MS210436	NUT
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

NUT

Batch: M110186

JH

43.0	MS21083C8	NUT
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

NUT

Batch: M110584

JH

44.0	NAS1515H3L	WASHER
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

WASHER

Batch: M110450

JH

45.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

✓ 1-Assemble tube hardware as per dwg D2750 sikaflex batch: M109833 09/11

✓ 2-Inspect For Foreign Objects

✓ 3-Spray inside of tube with "LPS-3" batch: M1109956

✓ 4-Install blade fitting D3488-041, wearshoe

SIKA FLEX 241

BATCH: M1109833

JH

09-02-09

JP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Description :

EXP DATE: 09/11

5-assemble o'ring as per dwg D3492 and apply o'ring lube

A/R 55-o'ring lube batch: M101223

6-Coat all exposed fasteners with "LPS Procyon" batch: M104251

JP 09-02-09 (XU)

46.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09.02.18 (XU)

47.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

48.0

D2741

Blade, 350 Skidtube



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Blade

Batch: 44031

JP 09/02/19 (XU)

49.0

AN960C816L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

Batch: M110139

JP 09/02/19 (XU)

50.0

MS21083C8

NUT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

Batch: M110468

JP 09/02/19 (XU)

51.0

AN8C21A

BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: 110665

JP 09/02/19 (XU)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number:



Seq. #: Machine Or Operation: Description :

52.0 NAS1515H8L WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

WASHER

Batch: M108964

SS 09/02/19 (X)

53.0 D34931 Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

WASHER

Batch: 44886

SS 09/02/19 (X)

54.0 QC4 INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

09-02-19 (1)

55.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Package as per PPP D350-636-014

Rev G

SS 09/02/19 (X)

56.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/02/20

Job Completion



mf 09-02-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

# GENERAL NOTES:

- MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH:  
ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.  
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- WELD PER DART QSI 004
- INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL "F" SIZE HOLES ( $\phi$ 0.297) FOR WEARSHOE INSERTS
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:  
MINIMUM YIELD TENSILE STRENGTH = 35 KSI  
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.  
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF  
POWDER COATING WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

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F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/-3 REPLACES D3535-13/-35 (ZN C8-1); D3794-1/-3 REPLACES D3536-13/-35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWDIAFT SADDLE REMOVED (8 PL). WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS, CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741, QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4, INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
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TITLE 350 SKIDTUBE ASSEMBLY		SCALE NTS	
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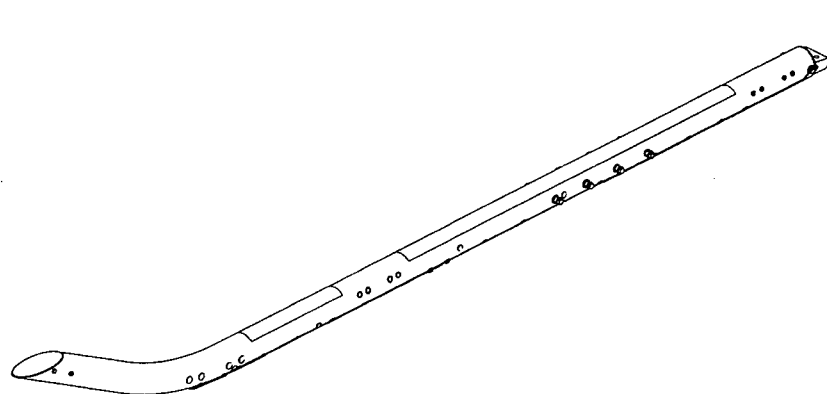
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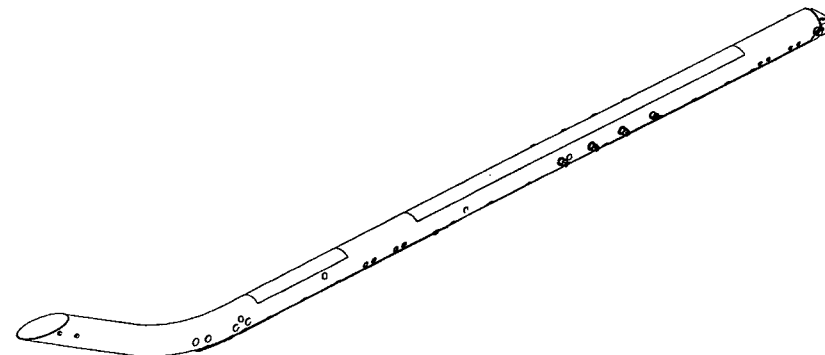
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D2750-041 350 SKIDTUBE ASSEMBLY, LH

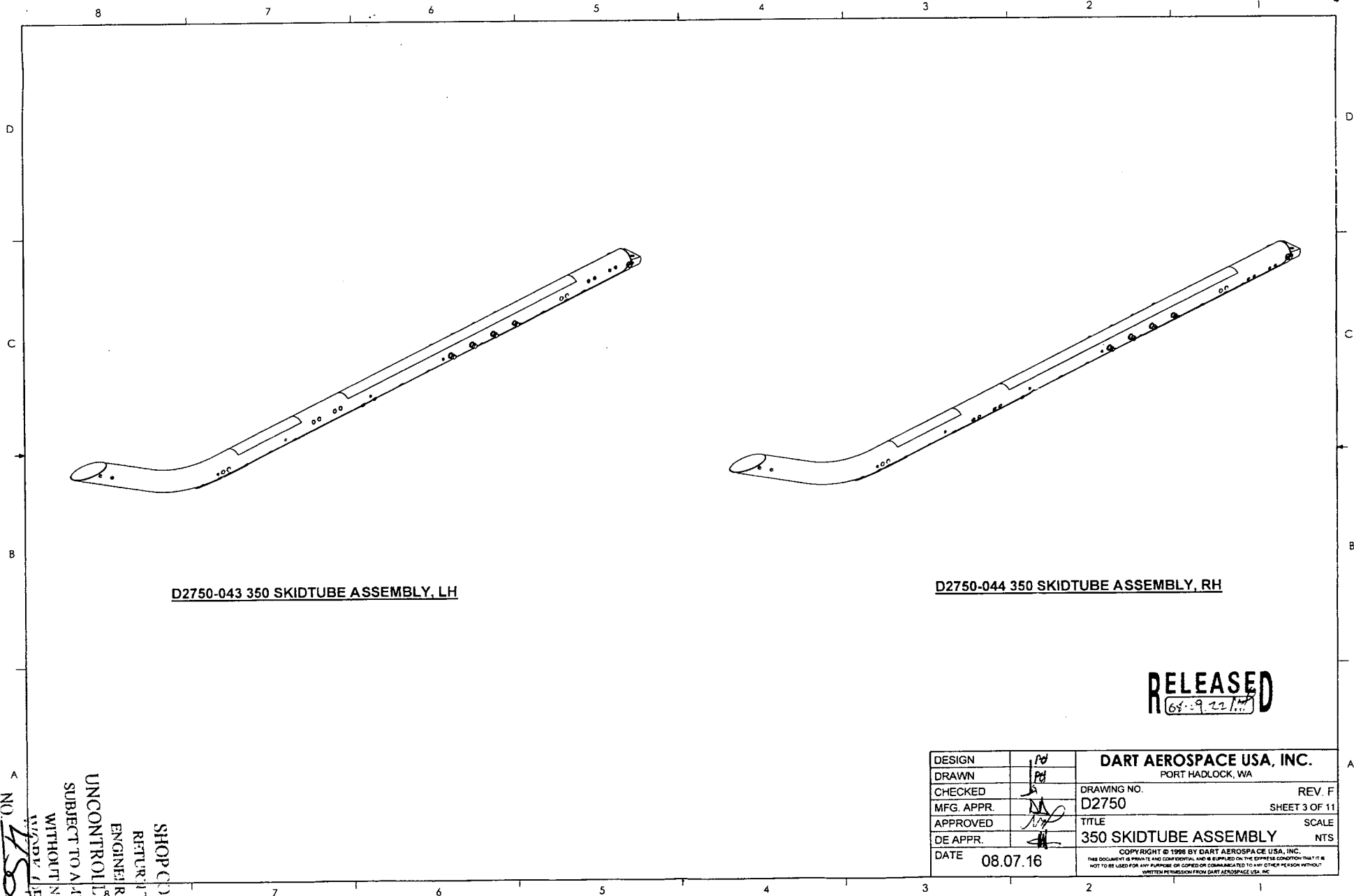


D2750-042 350 SKIDTUBE ASSEMBLY, RH

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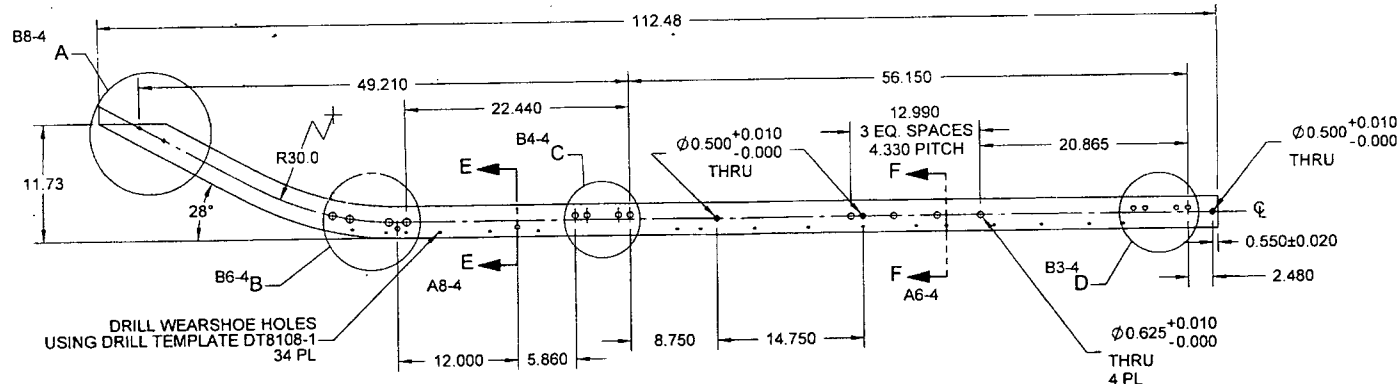
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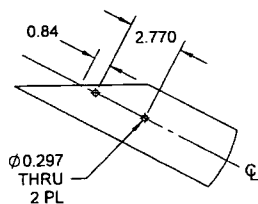
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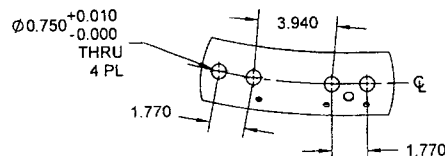
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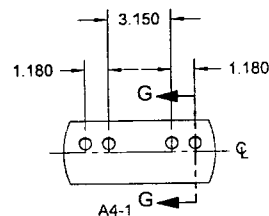
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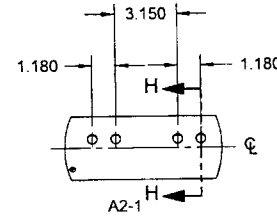
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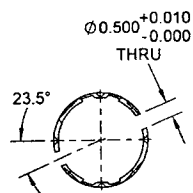
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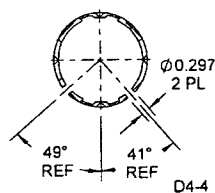
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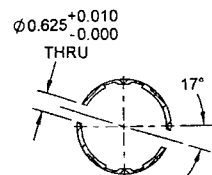
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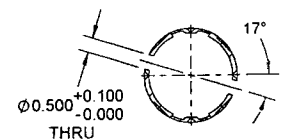
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SCALE 3X, 2 PL



**SECTION F-F**  
SCALE 3X, 17 PL



**SECTION G-G**  
SCALE 3X, 4 PL



**SECTION H-H**  
SCALE 3X, 4 PL

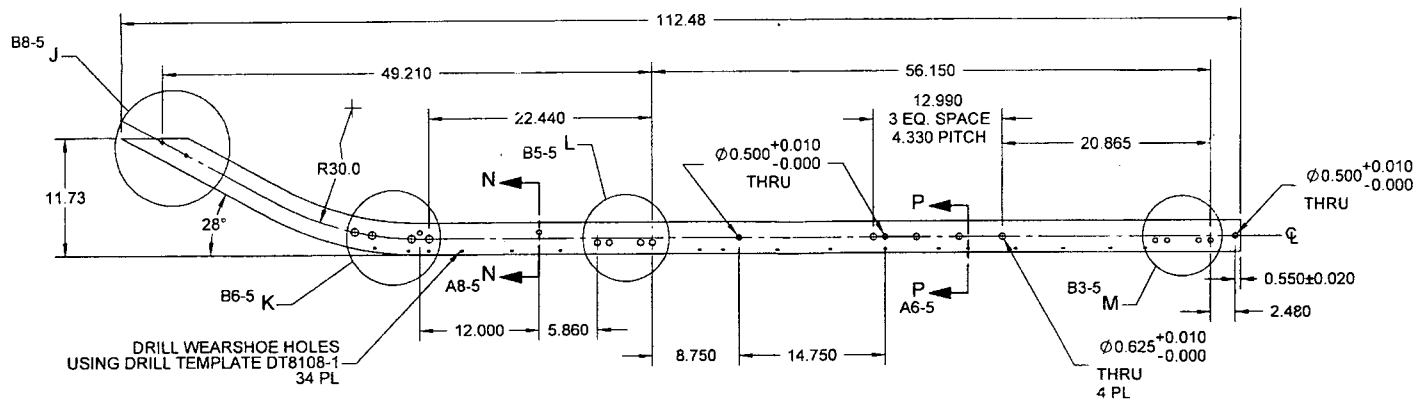
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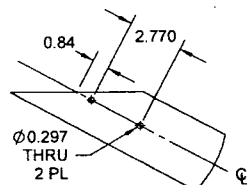
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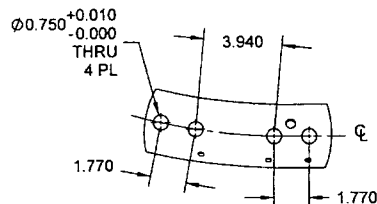




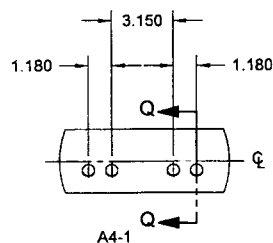
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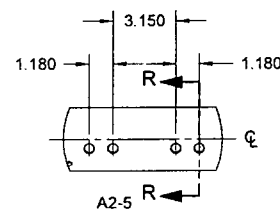
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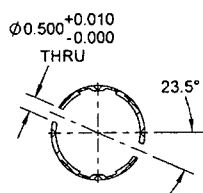
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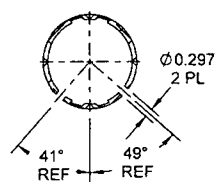
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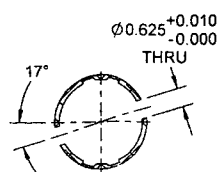
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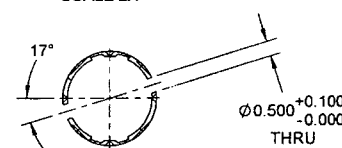
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**SECTION P-P**  
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**SECTION Q-Q**  
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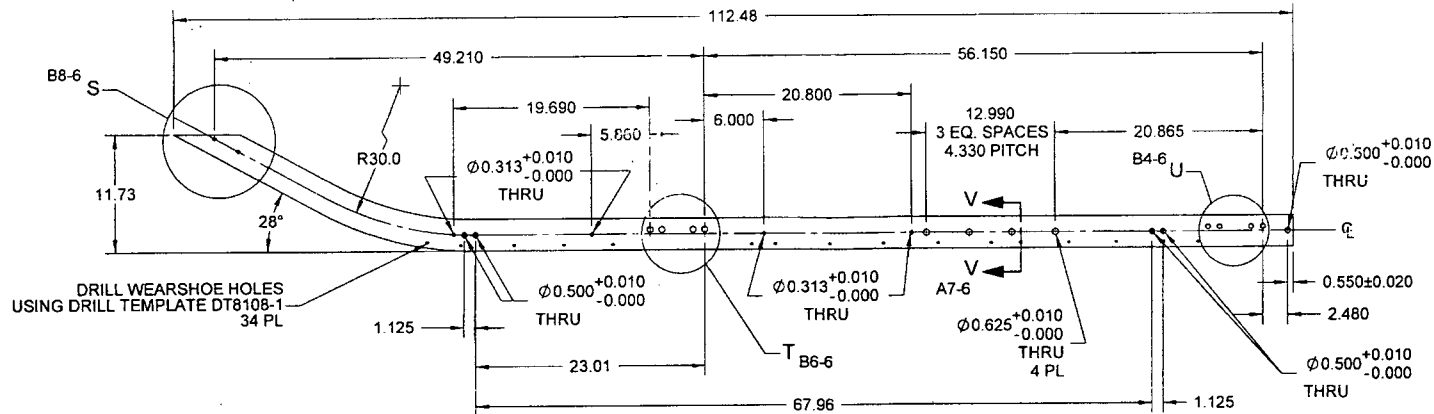
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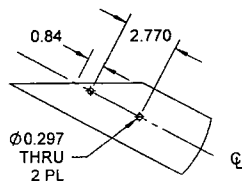
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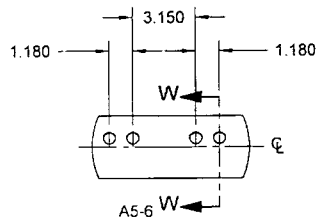
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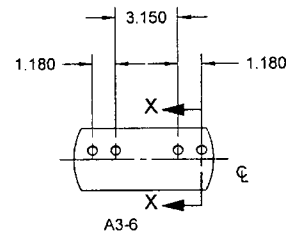
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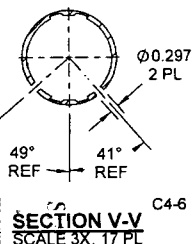
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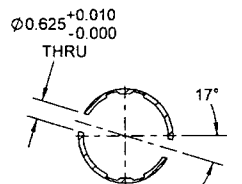
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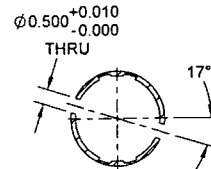
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**SECTION V-V**  
SCALE 3X, 17 PL



**SECTION W-W**  
SCALE 3X, 4 PL



**SECTION X-X**  
SCALE 3X, 4 PL

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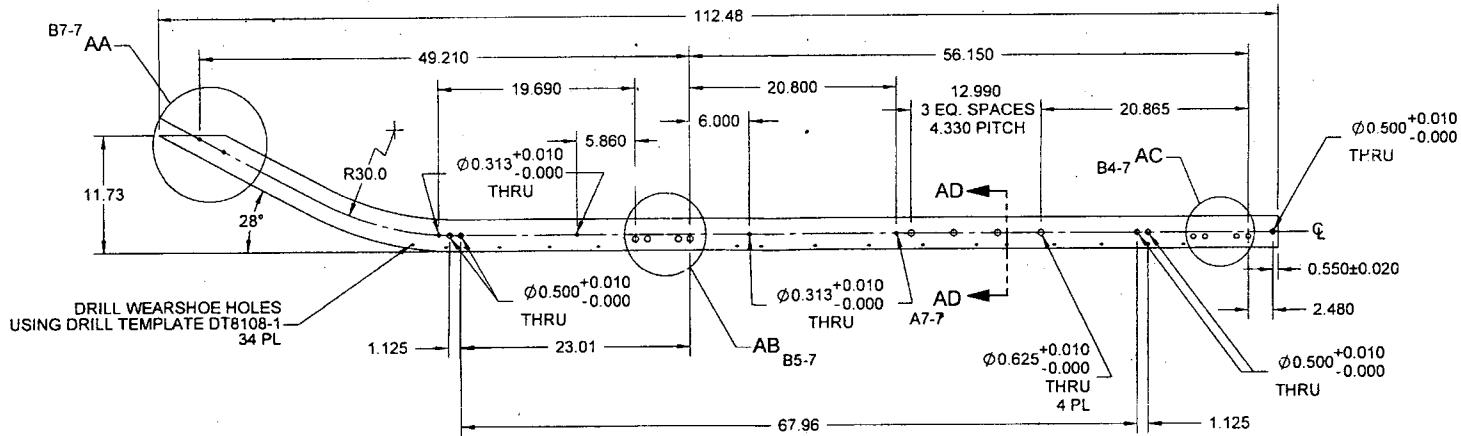
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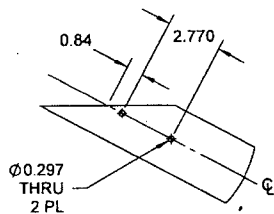
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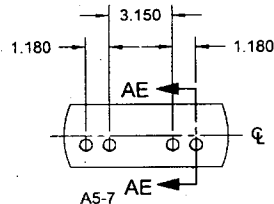
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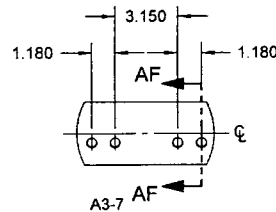
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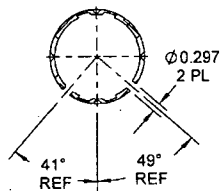
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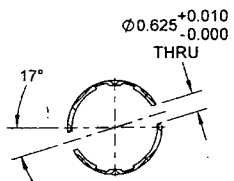
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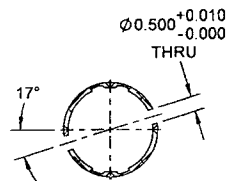
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**SECTION AD-AD**  
SCALE 3X, 17 PL



**SECTION AE-AE**  
SCALE 3X, 4 PL



**SECTION AF-AF**  
SCALE 3X, 4 PL

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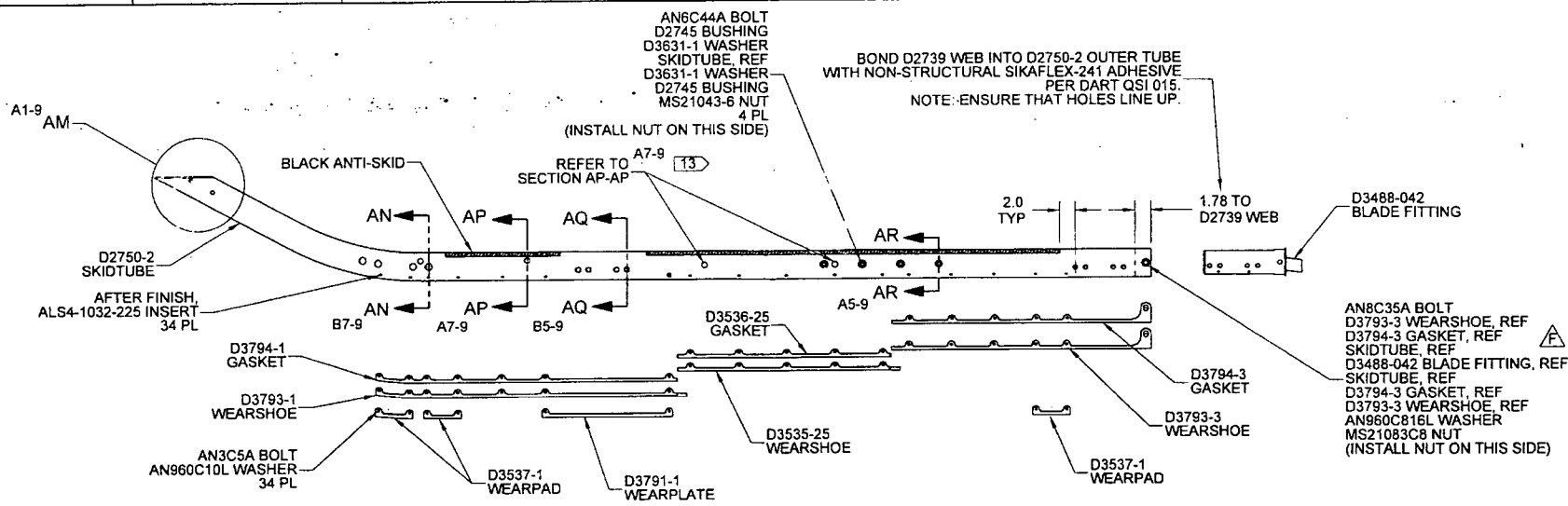
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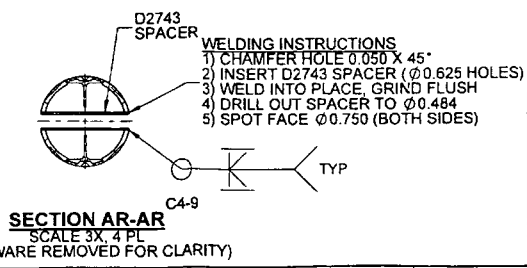
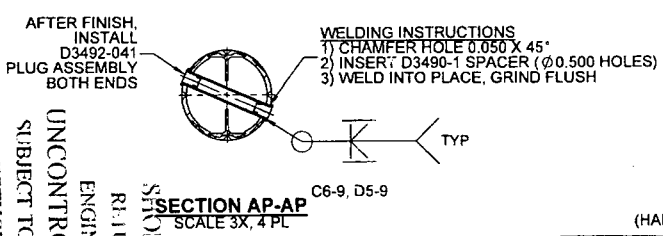
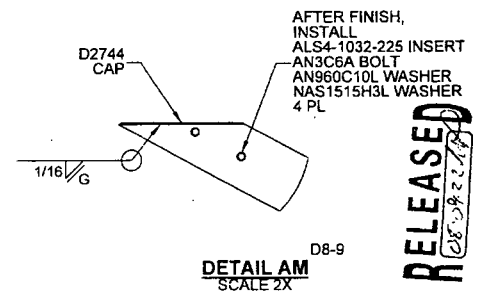
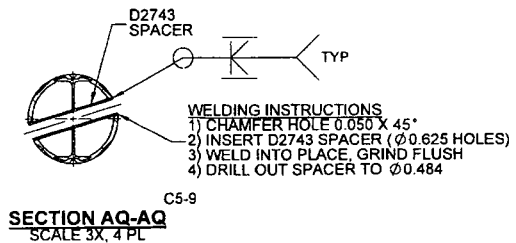
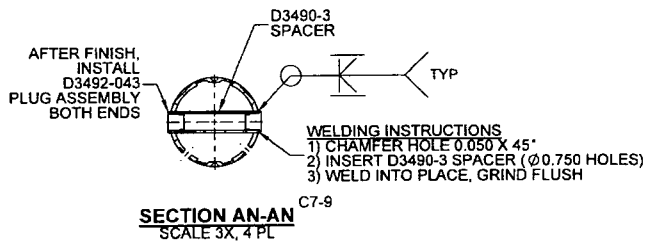
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**D2750-042 350 SKIDTUBE ASSEMBLY, RH**



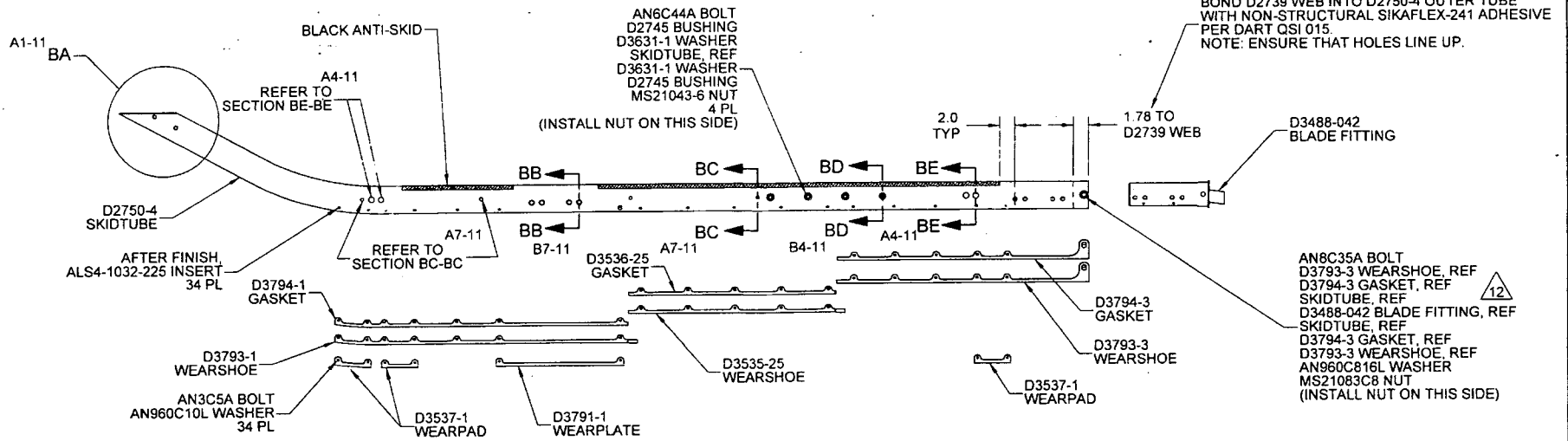
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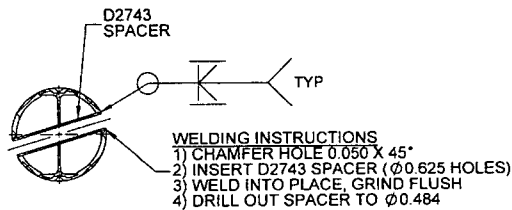
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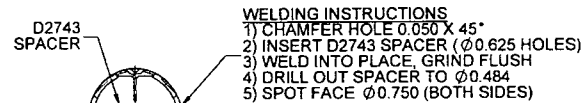
8 7 6 5 4 3 2 1



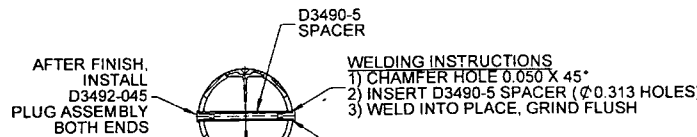
### D2750-044 350 SKIDTUBE ASSEMBLY, RH



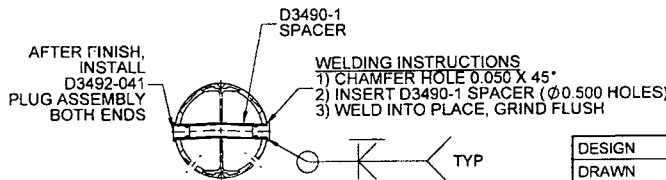
**SECTION BB-BB**  
SCALE 3X, 4 PL



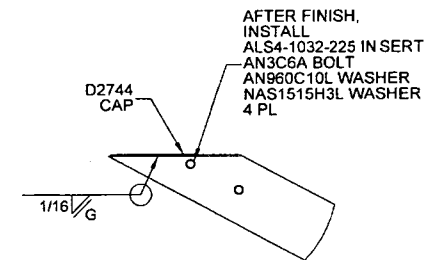
**SECTION BD-BD**  
SCALE 3X, 4 PL  
(HARDWARE REMOVED FOR CLARITY)



**SECTION BC-BC**  
SCALE 3X, 4 PL



**SECTION BE-BE**  
SCALE 3X, 4 PL



**DETAIL BA**  
SCALE 2X

DESIGN	REV. F	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	REV. F	PORT HADLOCK, WA	
CHECKED	REV. F	DRAWING NO. <b>D2750</b>	REV. F
MFG. APPR.	REV. F	TITLE <b>350 SKIDTUBE ASSEMBLY</b>	SHEET 11 OF 11
APPROVED	REV. F	SCALE	NTS
DE APPR.	REV. F	DATE <b>08.07.16</b>	

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RETURN TO  
ENGINEERING  
SUBJECT TO  
WORK ORDER  
NO. 45290

NO. 190

**AWS D17.1.2001**  
**QUALIFICATION TEST RECORD**

Name: Barclay Elliot  
Job number: 44808  
Part number: D350 626 0112  
Description: 350 skid tube  
Welding Process: Tig[☒] Mig[ ]  
Base material: Aluminium  
Current: AC[☒] DC[ ]

**TEST REQUIREMENTS AND RESULTS**

Visual: pass[☒] fail[ ]  
Penetration: pass[☒] fail[ ]

**UNACCEPTABLE**

Cracks: pass[☒] fail[ ]  
Undercut: pass[☒] fail[ ]  
Pin holes: pass[☒] fail[ ]  
Overlap (cold lap): pass[☒] fail[ ]  
Porosity (surface): pass[☒] fail[ ]  
Coloration: pass[☒] fail[ ]

Qualifier Pct. Dnt. Date of Test Coupon 09-01-27  
Welder Barclay Elliot Date of Test Coupon 09-01-27

The above named individual is qualified in accordance with AWS D17.1.2001 to weld